


# HIGH SPEED STEEL METRIC TAPER LENGTH DRILLS

ICS

WIS

GENERAL PURPOSE

118° POINT

ITEM NO.	ILLUSTRATION	CUTTING APPLICATION	STEEL SPECS	TECHNICAL DATA
<b>TLDM</b>	 <p>OXIDE FINISH</p>	For general purpose drilling where a longer than jobber length drill is required.	M2	118° Point Std. Spiral Std. Web

## Metric Sizes (Straight Shank) 1.00mm To 14.25mm Dia.

SIZE mm	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HSS
				OXIDE FINISH 118° PT TLDM
1.00	.0394	1-1/8	2-1/4	\$4.54
1.05	.0413	1-1/8	2-1/4	2.78
1.10	.0433	1-1/8	2-1/4	2.78
1.15	.0453	1-1/8	2-1/4	2.78
1.20	.0472	1-3/4	3	2.96
1.25	.0492	1-3/4	3	2.96
1.30	.0512	1-3/4	3	2.96
1.35	.0531	1-3/4	3	2.96
1.40	.0551	1-3/4	3	2.96
1.45	.0571	1-3/4	3	2.96
1.50	.0591	1-3/4	3	2.96
1.55	.0610	1-3/4	3	2.96
1.60	.0630	2	3-3/4	3.46
1.65	.0650	2	3-3/4	3.46
1.70	.0669	2	3-3/4	3.46
1.75	.0689	2	3-3/4	3.46
1.80	.0709	2	3-3/4	3.46
1.85	.0728	2	3-3/4	3.46
1.90	.0748	2	3-3/4	3.46
1.95	.0768	2	3-3/4	3.46
2.00	.0787	2-1/4	4-1/4	4.18
2.05	.0807	2-1/4	4-1/4	4.18
2.10	.0827	2-1/4	4-1/4	4.18
2.15	.0846	2-1/4	4-1/4	4.18
2.20	.0866	2-1/4	4-1/4	4.18
2.25	.0886	2-1/4	4-1/4	4.18
2.30	.0906	2-1/4	4-1/4	4.18
2.35	.0925	2-1/4	4-1/4	4.18
2.40	.0945	2-1/2	4-5/8	5.16
2.45	.0965	2-1/2	4-5/8	5.16
2.50	.0984	2-1/2	4-5/8	5.16
2.60	.1024	2-1/2	4-5/8	5.16
2.70	.1063	2-1/2	4-5/8	5.16
2.80	.1102	2-3/4	5-1/8	5.38
2.90	.1142	2-3/4	5-1/8	5.38
3.00	.1181	2-3/4	5-1/8	5.38
3.10	.1220	2-3/4	5-1/8	5.38
3.20	.1260	3	5-3/8	7.12
3.30	.1299	3	5-3/8	7.12
3.40	.1339	3	5-3/8	7.12
3.50	.1378	3	5-3/8	7.12
3.60	.1417	3	5-3/8	7.12
3.70	.1457	3	5-3/8	7.20
3.80	.1496	3	5-3/8	7.20
3.90	.1535	3	5-3/8	7.20
4.00	.1575	3-3/8	5-3/4	7.40
4.10	.1614	3-3/8	5-3/4	7.40
4.20	.1654	3-3/8	5-3/4	7.40
4.30	.1693	3-3/8	5-3/4	7.40
4.40	.1732	3-3/8	5-3/4	7.40
4.50	.1772	3-3/8	5-3/4	7.40

SIZE mm	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HSS
				OXIDE FINISH 118° PT TLDM
4.60	.1811	3-3/8	5-3/4	\$7.40
4.70	.1850	3-3/8	5-3/4	7.40
4.80	.1890	3-5/8	6	7.40
4.90	.1929	3-5/8	6	8.28
5.00	.1968	3-5/8	6	8.28
5.10	.2008	3-5/8	6	8.28
5.20	.2047	3-5/8	6	8.86
5.30	.2087	3-5/8	6	8.86
5.40	.2126	3-5/8	6	8.86
5.50	.2165	3-5/8	6	8.86
5.60	.2205	3-3/4	6-1/8	8.86
5.70	.2244	3-3/4	6-1/8	8.86
5.80	.2283	3-3/4	6-1/8	8.86
5.90	.2323	3-3/4	6-1/8	8.86
6.00	.2362	3-3/4	6-1/8	8.86
6.10	.2402	3-3/4	6-1/8	8.86
6.20	.2441	3-3/4	6-1/8	8.86
6.30	.2480	3-3/4	6-1/8	8.86
6.40	.2520	3-7/8	6-1/4	9.30
6.50	.2559	3-7/8	6-1/4	9.30
6.80	.2677	3-7/8	6-1/4	9.30
7.00	.2756	3-7/8	6-1/4	9.30
7.20	.2835	4	6-3/8	10.22
7.50	.2953	4	6-3/8	10.22
7.80	.3071	4	6-3/8	10.22
8.00	.3150	4-1/8	6-1/2	10.78
8.20	.3228	4-1/8	6-1/2	10.78
8.50	.3346	4-1/8	6-1/2	10.78
8.80	.3465	4-1/4	6-3/4	12.66
9.00	.3543	4-1/4	6-3/4	12.66
9.20	.3622	4-1/4	6-3/4	12.66
9.50	.3740	4-1/4	6-3/4	12.66
9.80	.3858	4-3/8	7	12.74
10.00	.3937	4-3/8	7	12.74
10.20	.4016	4-3/8	7	12.74
10.50	.4134	4-5/8	7-1/4	14.28
10.80	.4252	4-5/8	7-1/4	14.52
11.00	.4331	4-5/8	7-1/4	14.52
11.20	.4409	4-3/4	7-1/2	16.14
11.50	.4528	4-3/4	7-1/2	16.14
11.80	.4646	4-3/4	7-1/2	17.11
12.00	.4724	4-3/4	7-1/2	18.72
12.20	.4803	4-3/4	7-1/2	18.72
12.50	.4921	4-3/4	7-1/2	18.72
12.80	.5039	4-3/4	8	23.66
13.00	.5118	4-3/4	8	23.66
13.20	.5197	4-3/4	8	23.66
13.50	.5315	4-3/4	8	26.32
13.80	.5433	4-7/8	8-1/4	26.32
14.00	.5512	4-7/8	8-1/4	26.32
14.25	.5610	4-7/8	8-1/4	26.32

(Sizes continued on next page)